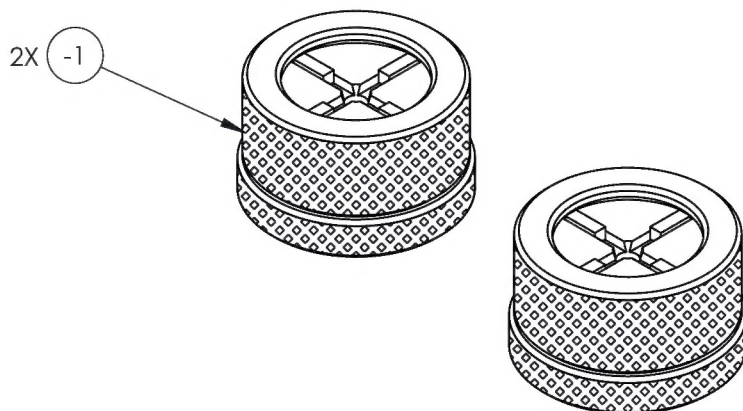


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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		RELEASED FOR PRODUCTION.	10/10/2016	DPD	JAG



#### NOTES:

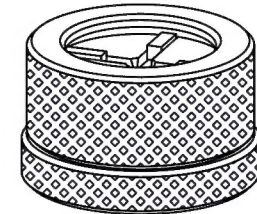
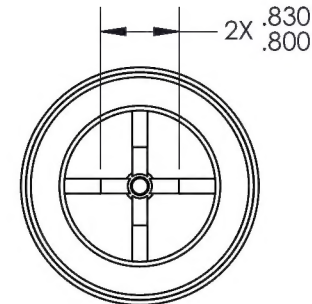
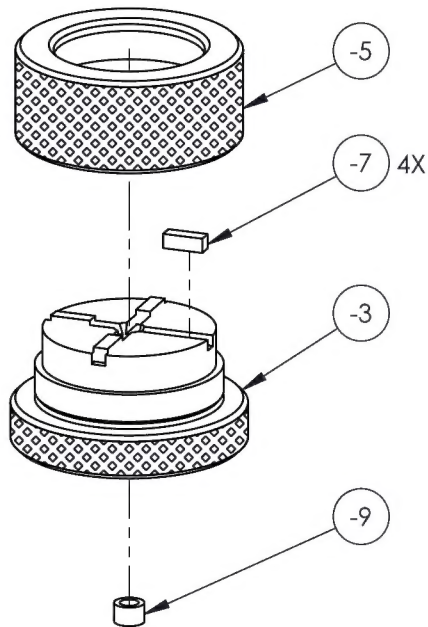
1. REF. EUROCOPTER T/N: 105-40001W1.
2. USED ON MODELS:  
EC135, EC145, EC635, EC645, H135.

<b>DART</b> AEROSPACE																				
TITLE <b>STAKING TOOL RETAINER</b>																				
DWG NO. <b>RBE105-40001W1</b>	REV <b>1</b>																			
<table border="1"> <tr> <td>MAT'L</td> <td rowspan="4">           UNLESS OTHERWISE SPECIFIED            DIMENSIONS ARE IN INCHES            .XXX ± .005 FRACTIONS ± 1/8            .XX ± .01 ANGLES ± .5°            .X ± .1 SURFACES = 125°            1. BREAK ALL SHARP EDGES            .015 x 45° OR .015R            2. DIMENSIONAL LIMITS APPLY            AFTER PLATING            3. INTERPRET DIM AND TOL PER            ASME Y14.5M-2009         </td> </tr> <tr> <td>TREAT</td> </tr> <tr> <td>FINISH</td> </tr> <tr> <td>SPEC</td> </tr> <tr> <td>DRAWN BY:</td> <td>DUERFELDT</td> </tr> <tr> <td>CHECKED:</td> <td>CLOUGH</td> </tr> <tr> <td>OPPS APPR:</td> <td>ANDERSON</td> </tr> <tr> <td>QA APPR:</td> <td>LINDSAY</td> </tr> <tr> <td>APPROVED:</td> <td>GILBERT</td> </tr> <tr> <td>SCALE 1:2</td> <td>DATE 1/19/2016</td> </tr> <tr> <td colspan="2">SHEET 1 OF 6</td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125° 1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	TREAT	FINISH	SPEC	DRAWN BY:	DUERFELDT	CHECKED:	CLOUGH	OPPS APPR:	ANDERSON	QA APPR:	LINDSAY	APPROVED:	GILBERT	SCALE 1:2	DATE 1/19/2016	SHEET 1 OF 6	
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OPPS APPR:	ANDERSON																			
QA APPR:	LINDSAY																			
APPROVED:	GILBERT																			
SCALE 1:2	DATE 1/19/2016																			
SHEET 1 OF 6																				

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
	X		-1	2	STAKING TOOL RETAINER ASSEMBLY			2
	1		-3		BASE	4140/4142		3
	1		-5		RETAINING RING	4140/4142		4
	4		-7		SLIDING PAD	S.S.	4mm X 4mm X 12" (MCMASTER-CARR #90457A420) MODIFIED	5
	1		-9		INSERT	NYLON		6
		B/O	-11	1	PISTOL CASE	PLASTIC	RSR GROUP #10137	N/S
	ASSY -1							

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
			INITIAL
			APPROVED



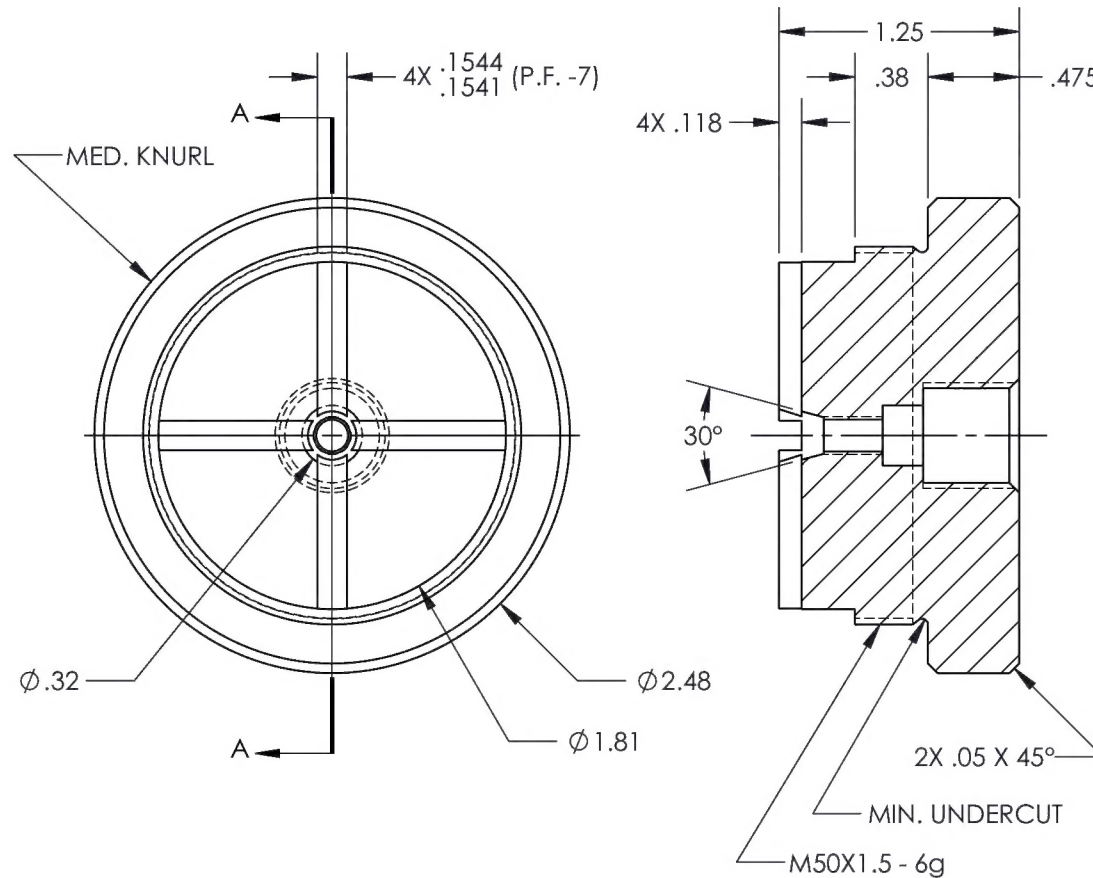
(-1)

STAKING TOOL RETAINER ASSEMBLY

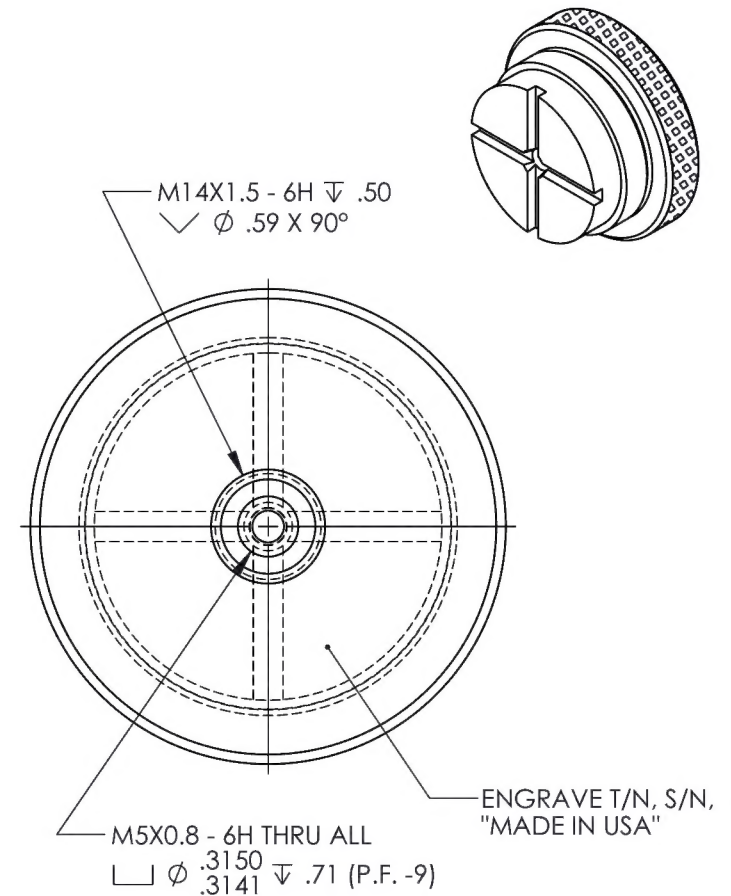
<b>DART</b> AEROSPACE	
TITLE <b>STAKING TOOL RETAINER</b>	
DWG NO. <b>RBE105-40001W1-1</b>	REV <b>1</b>
MAT'L REAT TREAT FINISH	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1 SURFACES = 125/
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: <b>DUERFELDT</b>	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: <b>CLOUGH</b>	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: <b>ANDERSON</b>	
QA APPR: <b>LINDSAY</b>	USED ON MODEL
APPROVED: <b>GILBERT</b>	SEE SHEET 1 NOTE 2
SCALE <b>1:2</b>	DATE <b>1/19/2016</b>
SHEET 2 OF 6	

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	



SECTION A-A

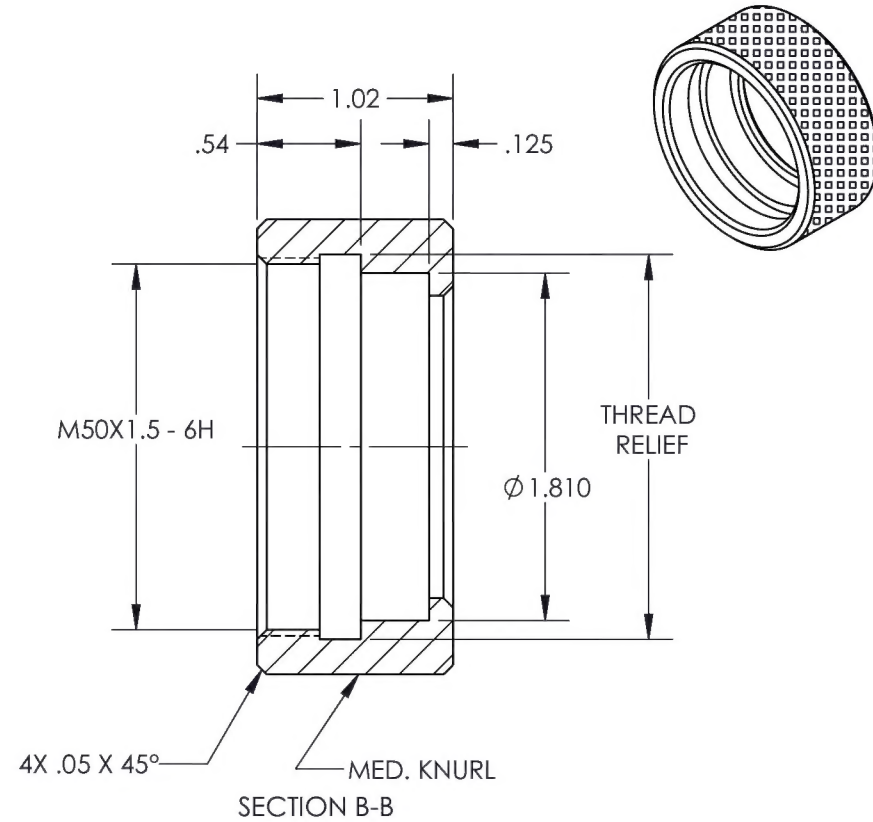
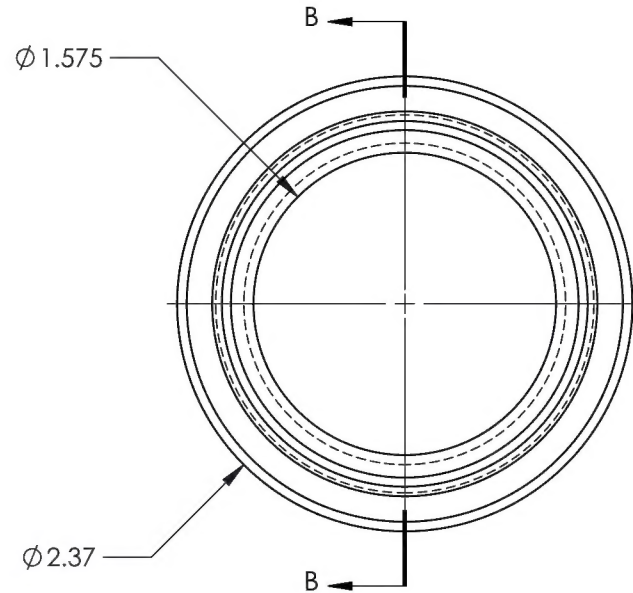


(-3)  
BASE

<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL RETAINER</b>	
DWG NO. <b>RBE105-40001W1-3</b>	REV <b>1</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 45-50	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX $\pm .005$ FRACTIONS $\pm 1/8$
SPEC ASTM B633 TYPE I SC 2	.XX $\pm .01$ ANGLES $\pm .5^\circ$
DRAWN BY: DUERFELDT	.X $\pm .1$ SURFACES = 125
CHECKED: CLOUGH	1. BREAK ALL SHARP EDGES
OPPS APPR: ANDERSON	.015 x 45° OR .015R
QA APPR: LINDSAY	2. DIMENSIONAL LIMITS APPLY
APPROVED: GILBERT	AFTER PLATING
SCALE 1:1	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
DATE 1/19/2016	USED ON MODEL
SHEET 3 OF 6	SEE SHEET 1 NOTE 2

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL

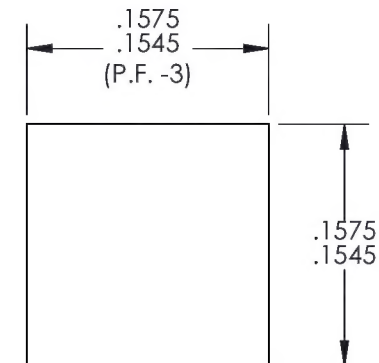
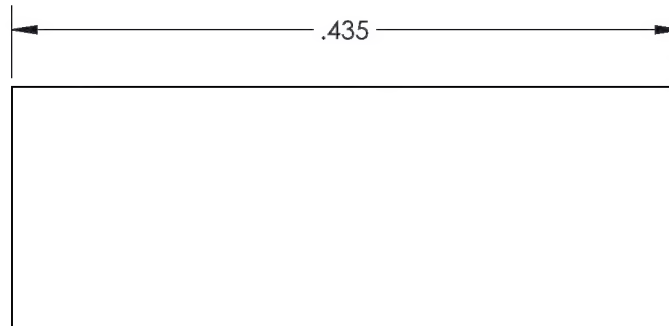
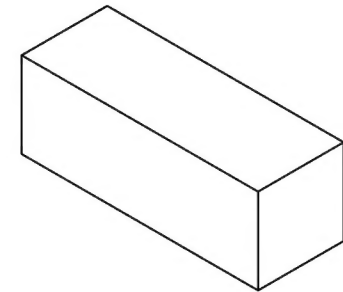


(-5)  
RETAINING RING

<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL RETAINER</b>	
DWG NO. <b>RBE105-40001W1-5</b>	REV <b>1</b>
MAT'L 4140/4142	UNLESS OTHERWISE SPECIFIED
HEAT TREAT RC 45-50	DIMENSIONS ARE IN INCHES
FINISH ZINC PLATE	.XXX ± .005 FRACTIONS ± 1/8
SPEC ASTM B633 TYPE I SC 2	.XX ± .01 ANGLES ± 5°
	.X ± .1 SURFACES = 125°
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 1:1	DATE 1/19/2016
	SEE SHEET 1 NOTE 2
	SHEET 4 OF 6

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REVISIONS						
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED	

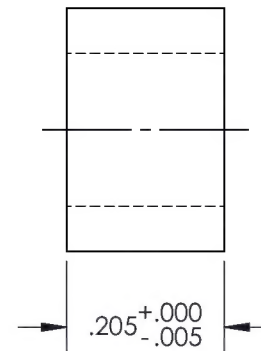
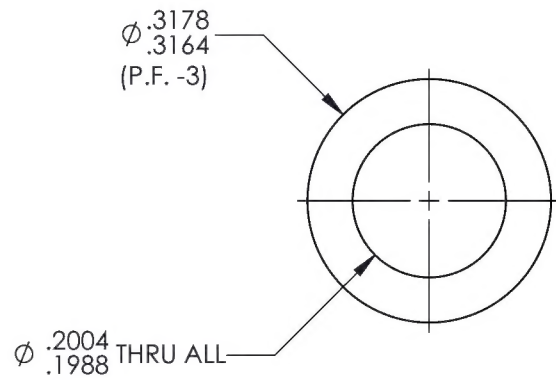
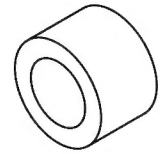


(-7)  
SLIDING PAD

<b>DART AEROSPACE</b>	
TITLE <b>STAKING TOOL RETAINER</b>	
DWG NO. <b>RBE105-40001W1-7</b>	REV <b>1</b>
MAT'L S.S.	UNLESS OTHERWISE SPECIFIED
HEAT TREAT	DIMENSIONS ARE IN INCHES
FINISH	.XXX ± .005 FRACTIONS ± 1/8
SPEC	.XX ± .01 ANGLES ± .5°
	.X ± .1 SURFACES = 125° ✓
DRAWN BY: DUERFELDT	1. BREAK ALL SHARP EDGES
CHECKED: CLOUGH	.015 x 45° OR .015R
OPPS APPR: ANDERSON	2. DIMENSIONAL LIMITS APPLY
QA APPR: LINDSAY	AFTER PLATING
APPROVED: GILBERT	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
SCALE 8:1	DATE 1/19/2016
	SHEET 5 OF 6

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
				APPROVED



(-9)

INSERT

<b>DART</b> AEROSPACE	
TITLE <b>STAKING TOOL RETAINER</b>	
DWG NO. <b>RBE105-40001W1-9</b>	REV <b>1</b>
MAT'L NYLON	UNLESS OTHERWISE SPECIFIED
HEAT TREAT FINISH	DIMENSIONS ARE IN INCHES .XXX $\pm$ .005 FRACTIONS $\pm$ 1/8 .XX $\pm$ .01 ANGLES $\pm$ 5° .X $\pm$ .1 SURFACES = 125°
SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
DRAWN BY: CLOUGH	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
CHECKED: CLOUGH	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
OPPS APPR: ANDERSON	USED ON MODEL
QA APPR: LINDSAY	SEE SHEET 1 NOTE 2
APPROVED: GILBERT	
SCALE 4:1	DATE 7/12/2016
SHEET 6 OF 6	



DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only ☐

Work Order: _____  Part No. <u>RBE101-40001W1-3/-5/-9/-11</u>  NCR No. _____	<b>DISPOSITION</b>  Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	<b>AGAINST DEPARTMENT/PROCESS</b>  <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube <input type="checkbox"/></td> <td style="border: none;">Cross tube <input type="checkbox"/></td> <td style="border: none;">Water Jet <input type="checkbox"/></td> <td style="border: none;">Engineering <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Machining <input type="checkbox"/></td> <td style="border: none;">Small Fab <input type="checkbox"/></td> <td style="border: none;">Prod. Eng. Coord. <input type="checkbox"/></td> <td style="border: none;">Quality <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Thermoforming <input type="checkbox"/></td> <td style="border: none;">Finishing <input type="checkbox"/></td> <td style="border: none;">Rec/Store/Packaging <input type="checkbox"/></td> <td style="border: none;">Other <input type="checkbox"/></td> </tr> <tr> <td style="border: none;">Large Fab <input type="checkbox"/></td> <td style="border: none;">Composite <input type="checkbox"/></td> <td style="border: none;">Supplier <input type="checkbox"/></td> <td style="border: none;"></td> </tr> </table>				Skid-tube <input type="checkbox"/>	Cross tube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																																																																																																																
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Date : _____	Step #: _____	QTY Effective : _____		<b>MRB (QSI042) Approval</b>  March 29, 2018																																																																																																																																
<b>Description Work Order Deviation</b>		<b>Disposition</b>		<b>Completed By</b>																																																																																																																																
- RBE101-40001W1-3/-5 can be manufactured from 17-4PH-H900 as an alternative material  - If manufactured from SS, Heat treat is no longer applicable  - If manufactured from SS, Zinc plate is no longer applicable  - RBE101-40001W1-9 material call-out is vague, manufacture from M-Delrin-R or MT-Nylon 6-R.  - Replace RSR Group Case 10137 with Black Pelican 1050 Case		- This deviation is acceptable.  - The drawings will be updated to reflect these changes.  - The fit, form and function of the tool will be as originally intended.		<b>Lead hand / Supervisor Approval Verification</b>																																																																																																																																
				<b>QC / QA Coordinator Approval</b>																																																																																																																																
<b>Root Cause</b>		<b>FAULT CATEGORY</b>																																																																																																																																		
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